

Work Order ID 92210

Tuesday, October 23, 2012 4:12:16 PM

92210

Item ID: PB67-43001-07 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Blade Fold Assembly Weldment
 Start Date: 10/23/2012 Start Qty: 2.00 *?
 Required Date: 11/2/2012 Req'd Qty: 2.00 *?
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 12-10-25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-07	Rev C								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- assemble parts on jig DT8813 and weld as per dwg PB67-43001*** ensure no burn thru after welding in tube -205 and -197 only where bushing -265 ***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

2 12-12-06

12-12-06 **DAS 09 9-89**

12-12-06 **DAS 09 9-89**

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Item ID: PB67-43001-07 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Fwd Blade Fold Assembly Weldment
Start Date: 10/23/2012 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 11/2/2012 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating m18144	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo ***mask inside of D3440-5, D3440-1 and D3440-15 prior to paint***START TIME: 2:15 OVEN TEMPERATURE 320°F FINISH TIME: 2:45	0.00				2X4			mt 12/12/10
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				2φ		12/12/10	2433
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>WMA</u> Memo	0.00				2	φ		12-12-10

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Item ID: PB67-43001-07

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Blade Fold Assembly Weldment

Stop ***NS2***

Start Date: 10/23/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/1/10 [Signature]

ME
13-01-07

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Required Qty: 2.00

IPP rev B 10.09.24 per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-47 Base Assembly		Manufactured	No	B92108 = 2		100	Each	0.0000	1	2		12.12.06	
PB67-43001-197 Outer Tube		Manufactured	No	B90913 = 2		100	Each	0.0000	1	2		12.12.06	
PB67-43001-201 Square Tube		Manufactured	No	B92212 = 2		100	Each	0.0000	1	2		12.12.06	
PB67-43001-203 Square Tube		Manufactured	No			100	Each	4.0000	1	2		12.12.06	
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>						
				ST437	B90915 = 2	4				2			
					62105	4							
PB67-43001-205 Outer Tube		Manufactured	No	B90916 = 2		100	Each	0.0000	1	2		12.12.06	
PB67-43001-207 Square Tube		Manufactured	No	B90917 = 2		100	Each	0.0000	1	2		12.12.06	
PB67-43001-209 Square Tube		Manufactured	No	B90918 = 2		100	Each	0.0000	1	2		12.12.06	
PB67-43001-211 Square Tube		Manufactured	No			100	Each	2.0000	6	12		12.12.06	
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>						
				WA	B90919 = 12	2				12			
					85179	2							
PB67-43001-219 Angled Male Eye		Manufactured	No			100	Each	6.0000	1	2		12.12.06	
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>						
				ST438		6							
					52606	6				2			

Picklist Print

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Work Order ID: 92210

Parent Item: PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-223 Square Cap

Manufactured

No

N/A

100

Each

43.0000

1

2

Location

Loc Qty

Loc Code

Mezz

43

47504

43

D3440-7

Detent Clip Base (Supersedes B67-43001-221)

Manufactured

No

B 92214 = (2) 100

Each

0.0000

1

2

11.12.06

D3440-5

Contoured Detent Clip Base (Supersedes B67-43001-217)

Manufactured

No

B 92213 = (2) 100

Each

0.0000

1

2

11.12.06

D3440-15

Contoured Male Eye (Supersedes B67-43001-215)

Manufactured

No

B 92215 = (2) 100

Each

3.0000

1

2

11.12.06

Location

Loc Qty

Loc Code

ST439A

3

62186

3

2

~~B PB67-43001-221~~

~~B PB67-43001-227~~

Location
Stores

44987
B 43712 = (4)

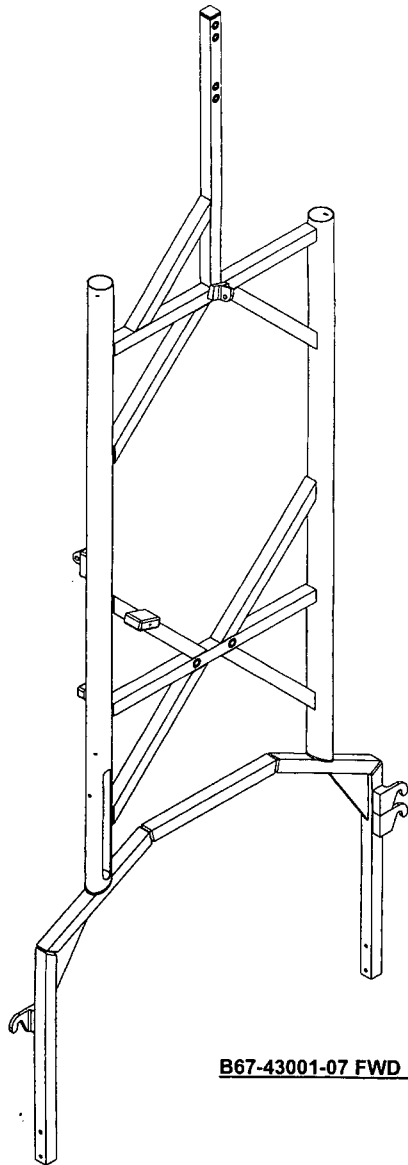
4

11.12.06

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Shop Packet Print

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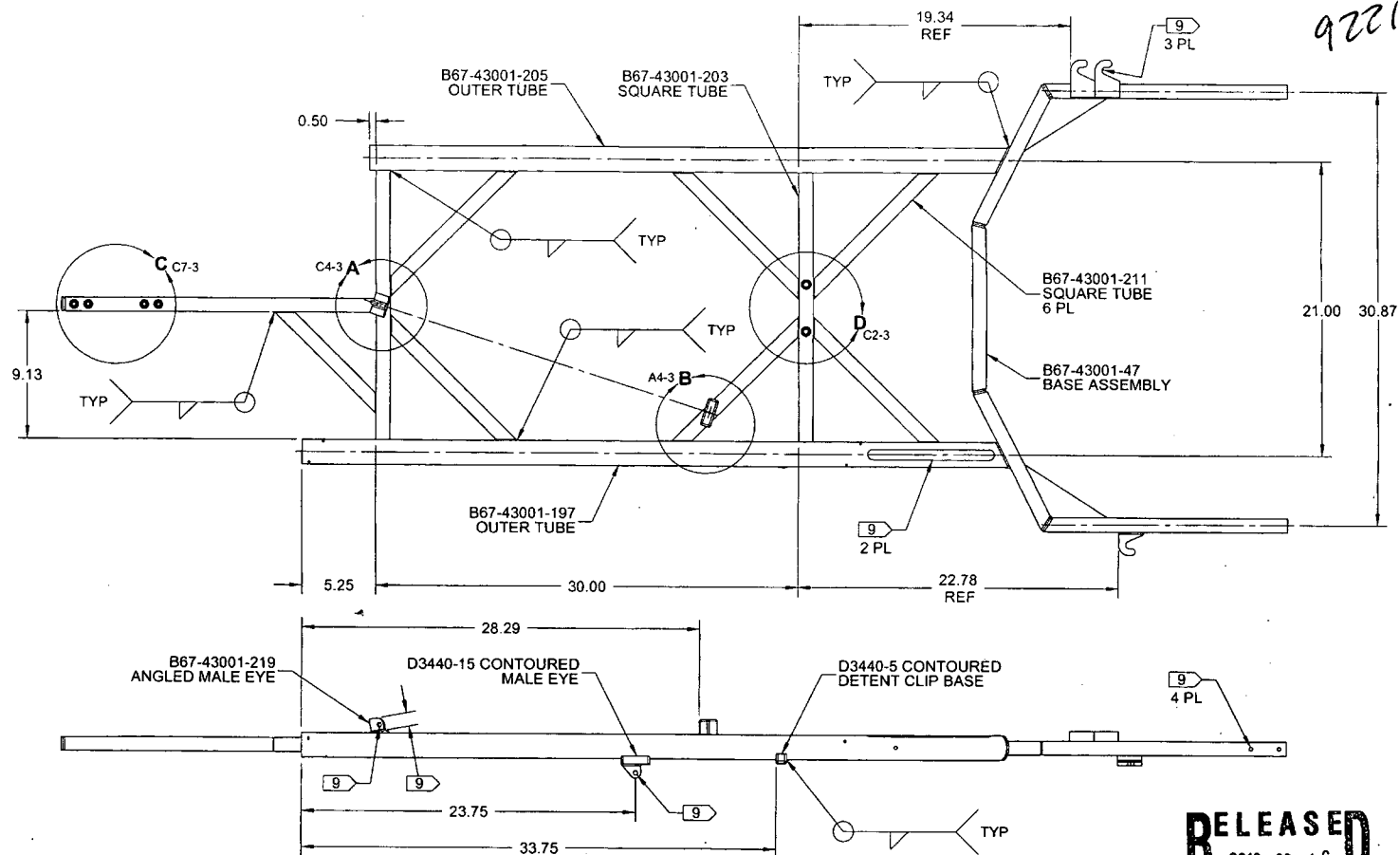
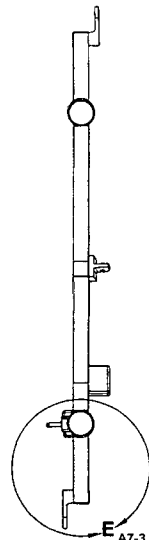
B67-43001-07 FWD BLADE FOLD ASSY WELDMENT

COPY
TO
FOR
ED COPY
WELDMENT
SQUARE
ORDER
92210 MLS
12-10-25

ITEM	QTY -07	P/N	DESCRIPTION
1	X	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-47	BASE ASSEMBLY
3	1	B67-43001-197	OUTER TUBE
4	2	B67-43001-199	OUTER TUBE END CAP
5	1	B67-43001-201	SQUARE TUBE
6	1	B67-43001-203	SQUARE TUBE
7	1	B67-43001-205	OUTER TUBE
8	1	B67-43001-207	SQUARE TUBE
9	1	B67-43001-209	SQUARE TUBE
10	6	B67-43001-211	SQUARE TUBE
11	1	B67-43001-219	ANGLED MALE EYE
12	1	B67-43001-223	SQUARE CAP
13	4	B67-43001-225	BUSHING
14	2	B67-43001-227	BUSHING
15	1	D3440-5	CONTOURED DETENT CLIP BASE
16	1	D3440-7	DETENT CLIP BASE
17	1	D3440-15	CONTOURED MALE EYE

RELEASED
2010-09-16
AM

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 5 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.05.04
REV.	DESCRIPTION	BY	DATE	
DESIGN	FW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-07 REV. C SHEET 1 OF 3 TITLE FWD BLADE FOLD ASSY WELDMENT SCALE NTS		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A			
DATE	10.05.04	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



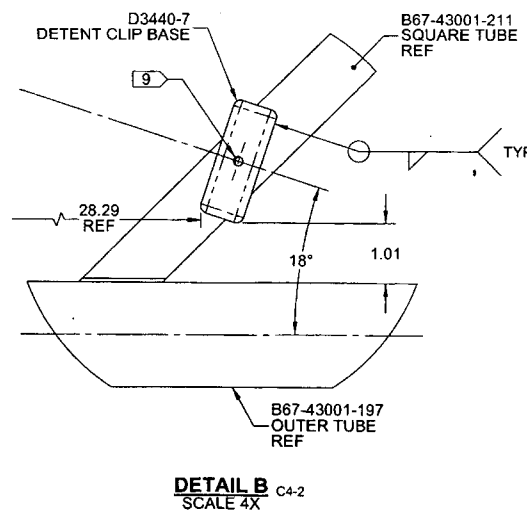
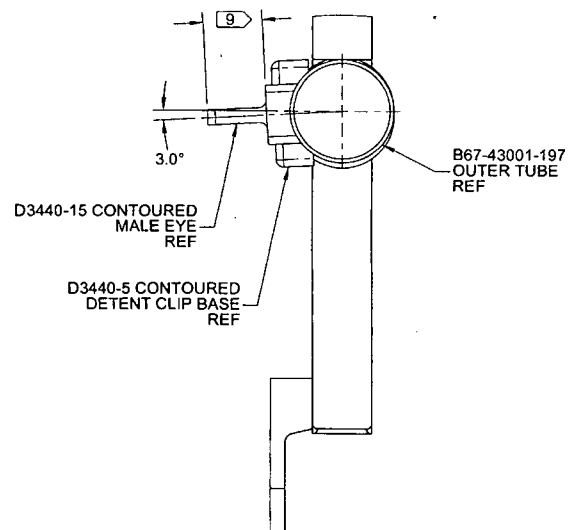
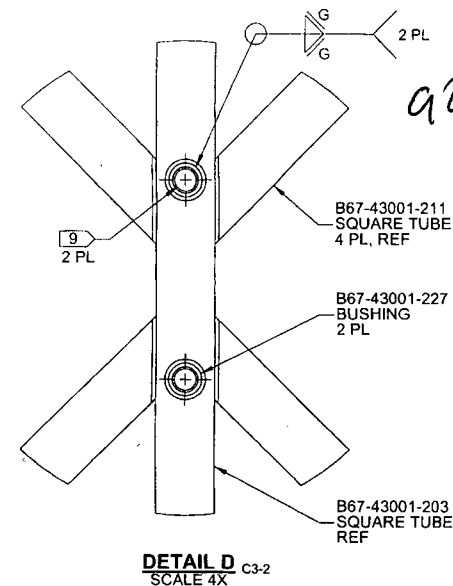
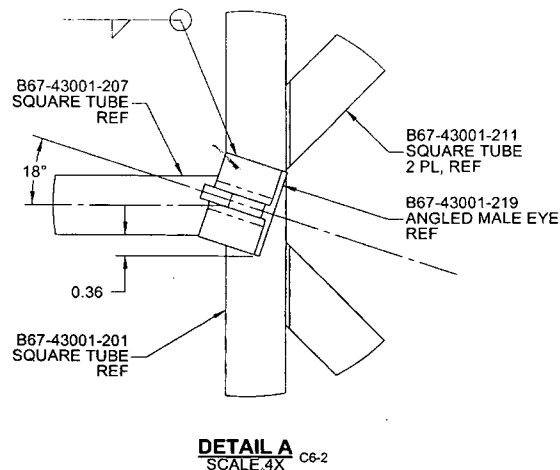
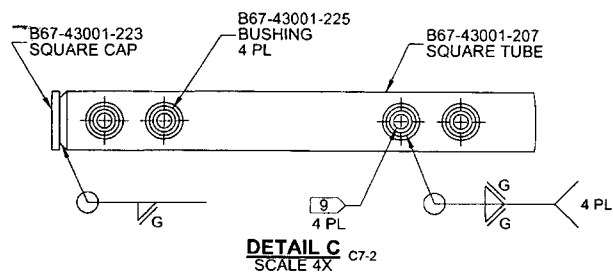
B67-43001-07 FWD BLADE FOLD ASSY WELDMENT

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2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.78 lbs
- 8) WELDING: PER QSI 004
- 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-07	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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